



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4853-1
Job Sheet 171744



Part No: D4853-1

Job Qty: 12 ea

Part Name: Top Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/8/18

Job Tracking No:

Due Date: 2/16/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: D4853 REV.B IPP REV:A NEW ISSUE 13-07-17 JLM VERIFIED BY:DD IPP REV:B 17.10.20 AS PER DWG
REV.B DD VERIFIED BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	2/15/18	2/15/18	0.00	0.00	Start Up Waterjet		DE 18/02/09
110	Waterjet	12 pcs	2/15/18	2/15/18	0.00	3.00	Waterjet1		DE 18/02/09
120	QC	12 pcs	2/15/18	2/15/18	0.00	0.00	QC2 Waterjet-4		DE 18/02/09
125	Mill Conv	12 pcs	2/15/18	2/15/18	0.00	6.00	Mill Conv 2		J.L. 18-02-12
130	QC	12 pcs	2/15/18	2/15/18	0.00	0.00	QC8-7		J.L. 18-02-13
140	HandFinish	12 pcs	2/15/18	2/15/18	0.00	0.32	HandFinish1		18-02-13
150	QC	12 pcs	2/15/18	2/15/18	0.00	0.00	QC7-4		18-02-13
160	Powdercoat	12 pcs	2/16/18	2/16/18	0.00	0.12	Powdercoat1		18-02-13
170	QC	12 pcs	2/16/18	2/16/18	0.00	0.00	QC3		38
180	Packaging	12 pcs	2/16/18	2/16/18	0.00	0.00	Packaging3-2		21
190	QC21-SA	12 Ea	2/16/18	2/16/18	0.00	0.00	QC21		21

Part Op 110 - 1-Cut as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary

Descriptions: 125 - MILL RADS DRILL HOLES AS PER DWG USE DT10105 ,ORIENT FIXTURE WITH RED FACE ON SAME SIDE
WHEN FLIPPING FIXTURE FROM SIDE TO SIDE DEBURR

160 - START TIME: 2:25 OVEN TEMPERATURE: 320 FINISH TIME: 2:25

M138407

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X04.000	6061-T6 Bar .750 X 4.00	4.5000 ft (.375 ea)	90-Start up Operation	

5041070 > M12751042

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.750X04.000	5	8	0

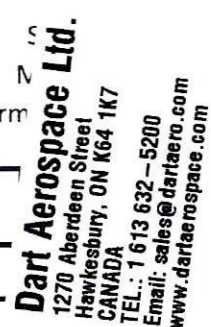
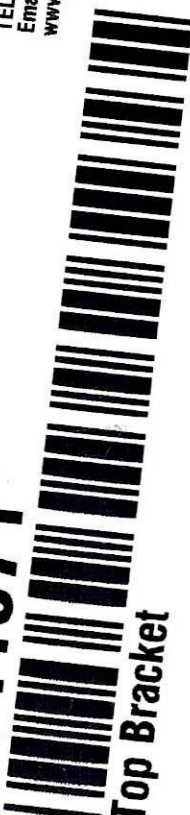
Part Specifications

Specifications could not be found.

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Therm ☐ Engineering ☐ Quality ☐ Other ☐ QSI042) Approval _____ Completed By _____ d hand / Supervisor approval Verification _____ QC / QA Coordinator Approval _____							
Date : _____		Step #: _____		 Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com  Top Bracket PART NO: D4853-1 Original Serial #: S041071 Revision: Operation: Change No: Start up Operation 02/10/18 Job No: 171744							
Description Work Order Deviation											
Root Cause <table border="0" style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table border="0" style="width:100%;"> <tr> <td style="width:50%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%;"> Instructions missing ☐ Drill Holes ☐ </td> </tr> </table>		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Instructions missing ☐ Drill Holes ☐	<table border="0" style="width:100%;"> <tr> <td style="width:50%;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> <td style="width:50%;"> OTHER : _____ </td> </tr> </table>		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____
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Container Trace

S041071 Container Trace - Upstream

Output Serial No	Depleted Serial No	Status	Part No/Material	Operation Code	Op No	Depleted Date	Depleted Qty	Unit	Location	Serial No/Batch	Job No	Workcenter Code	Manufacturer Part No	Mz
S036858	M127510-142	Stock	M6061T6B0.750X04.000	Receive Ft	100	1/30/2018 9:48 AM	5.400	ft	MAT002					
S041070	M127510-142	Stock	M6061T6B0.750X04.000	Receive Ft	100	2/10/2018 7:36 AM	1.600	ft	MAT002					
S041071	S036858	Allocated	M6061T6B0.750X04.000	Start up Operation	90	2/10/2018 7:38 AM	0.492	ft	Start Up Waterjet		171744	Start Up Waterjet		
S041071	S041070	Allocated	M6061T6B0.750X04.000	Start up Operation	90	2/10/2018 7:38 AM	0.948	ft	Start Up Waterjet		171744	Start Up Waterjet		

S041071 Details

Part No	Operation	Material	Status	Quantity	Net Weight	Add Date	Add By	Job No	Location	Serial No/Batch
D4853-1	QC21-SA		Stock	12.000	0.000	2/10/2018 7:38 AM	Dereck Conway	171744	ST519	S041071

Plex 2/15/2018 8:51 AM dart.Lacelle.Linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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